

Work Order ID 86200

June-22-12 1:57:08 PM

86200

Page 1

Item ID: D2362-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 350 Pre-Flite Step

Stop

NS2

Start Date: 22/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2362	Rev E1								
100	*Weld per dwg A/R Aluminum rod Batch: <u>120834</u> Large Fab <u>122130</u>	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	Cut D2244 extrusion 3.75" long Deburr D2244-3.75 Weld D2244-3.75 to D2362-7 as per Dwg D2362and QSI 004								
105	QC6- Inspect dimensions to drawing	0.00							
105									
QC	Memo	0.00							
Quality Control									
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

6

0

12-07-18

6x

12-07-18

6

8

12-07-19

12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 86200

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Item ID: D2362-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: 350 Pre-Flite Step

Stop *NS2*

Start Date: 22/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

120

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

130

QC3- Inspect Part Finish

0.00

130

QC

Quality Control

Memo

0.00

140

HandFinishing

0.00

140

HandFinish

Hand Finishing

Memo

Mask bracket and apply black anti-skid paint as per QSI 005 4.4

0.00

6x Ø

mt
12/07/19

6x Ø

mt
12/07/19

6x Ø

mt
12/07/19

9=30
320 JF
10=00

MT21505

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D2362-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 350 Pre-Flite Step

Start Date: 22/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>480</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

6 0 12-7-12

12/1/2012

12/1/2012

ME
12-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-22-12 1:57:12 PM

Page 1

Work Order ID: 86200

86200

Parent Item: D2362-041

D2362-041

Parent Item Name: 350 Pre-Flite Step

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C00.06.26Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured

No

100

Each

76.5000

1

6

D2244-116

Step Extrusion

**

12.07.18

Location

Loc Qty

Loc Code

WA

360307

76.5

6

80803

76.5

D2362-7

Manufactured

No

100

Each

5.0000

1

6

D2362-7

Support Bracket

**

12.07.18

Location

Loc Qty

Loc Code

WA

386350

5

70060

5

1

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

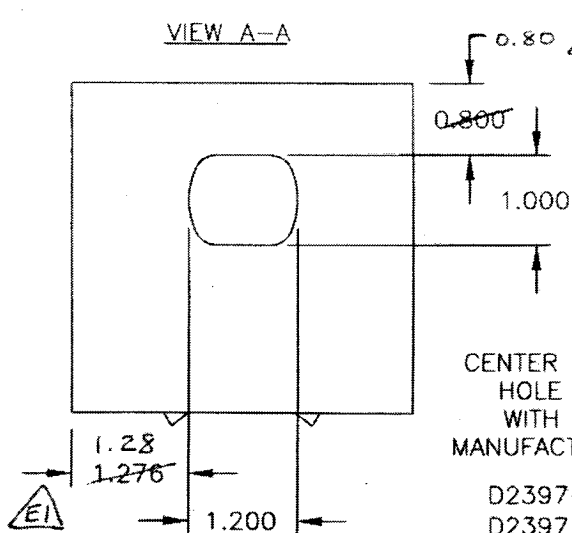
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

EI 03.10.07 TOLERANCE CHANGE ~~RT~~

VIEW A-A

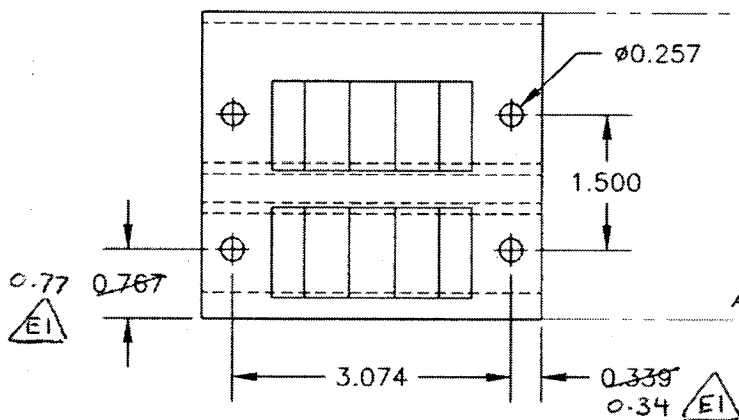
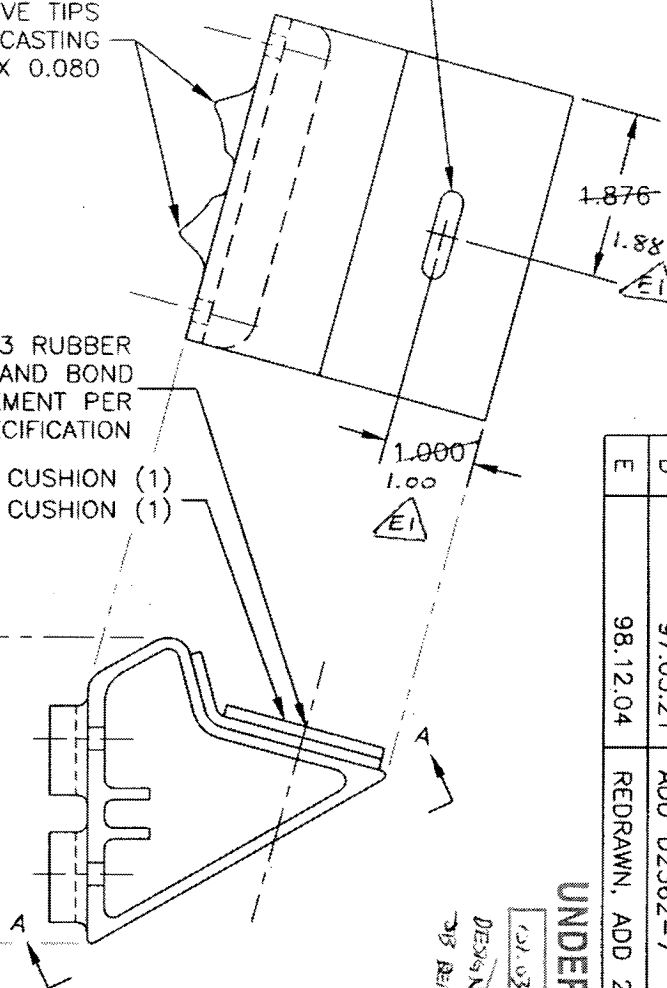


REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

0.257 X 0.75 SLOT



D2362-3

NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNDER REVIEW

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE
OK 18/11/99

RELEASED
98.12.14 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06200
MLJ
12/08/22



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	SP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2362
DATE	TITLE	SHEET 1 OF 3
98.12.04	STEP SUPPORT BRACKET	1-2
REV.	DATE	DESCRIPTION
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

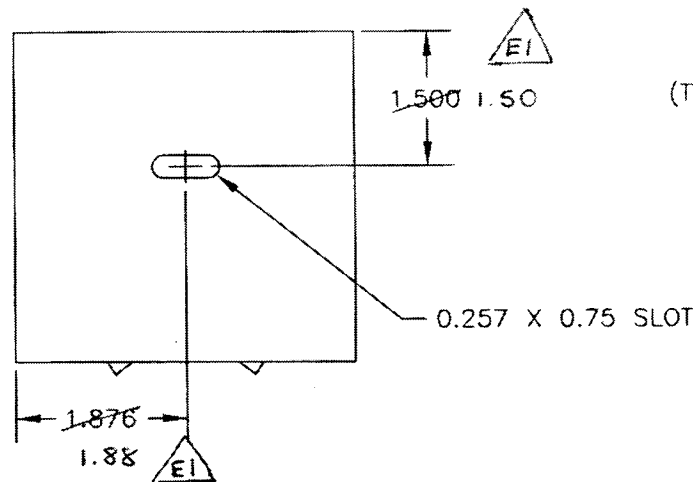
NOTE: Date & initial all entries

86200



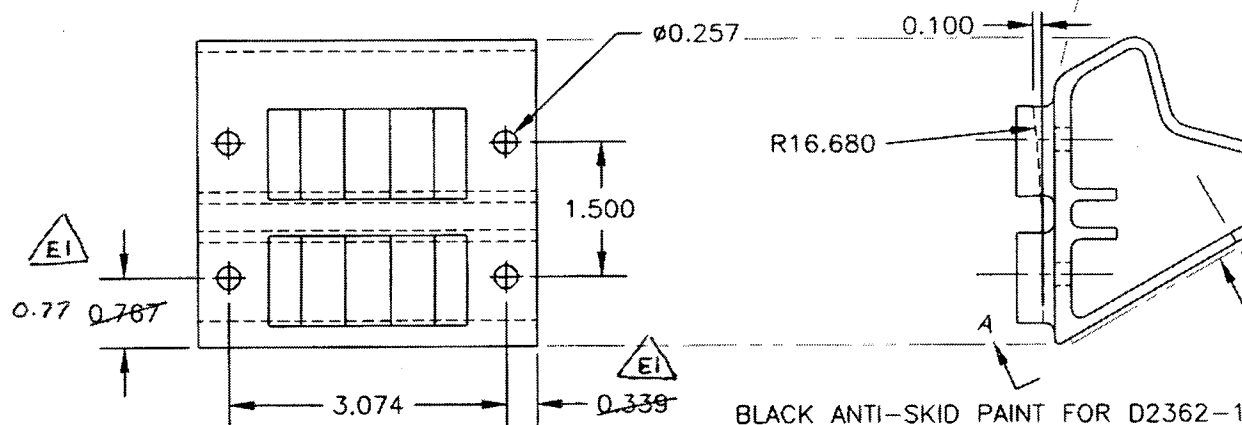
DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	REV. E
CHECKED	KE	APPROVED	SP	HAWKESBURY, ONTARIO, CANADA	
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	DRAWING NO.	D2362
				SHEET 2 OF 3	
				SCALE	1:2

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.12.14
UNDER REVIEW

DESIGNER, BUT CHECK BY
D2362-5 MANUFACTURE

OK
CP
98.12.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86200.



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	ME	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	REV. E
				SHEET 3 OF 3
				SCALE 1:2

D2362-041 (SHOWN)

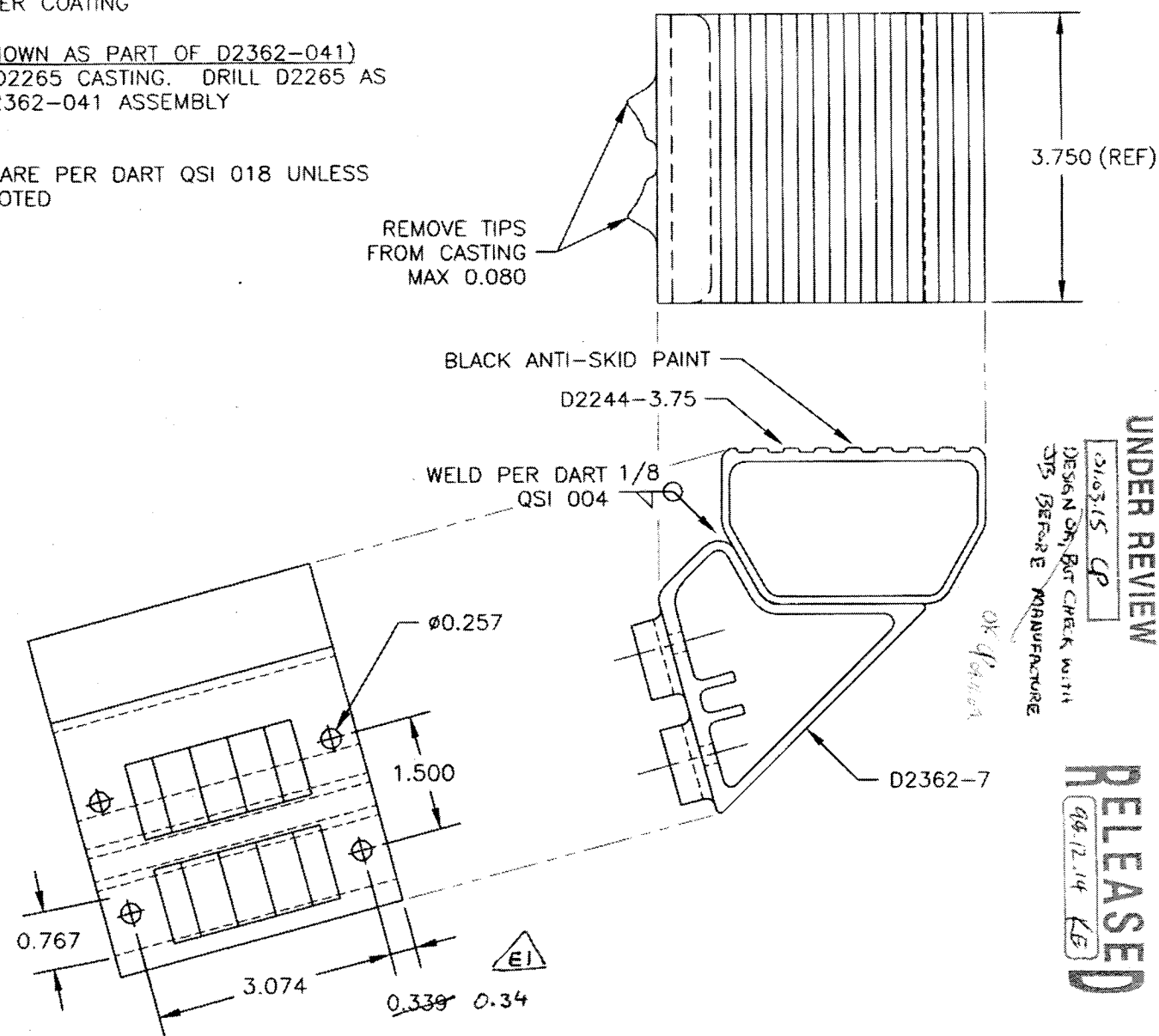
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



UNDER REVIEW

0103.15 CP
DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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